

Date: Tuesday, 1/3/2006 4:20:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB	
Job Number	: 25382		Part Number	: D2923	
Estimate Number	: 10482		Drawing Number	: D2923 REV.A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/3/2006	S.O. No. : N/A	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/25/2006	
Previous Run	: 24771		Qty:	4	Um: Each
Written By	: SEE COMMENT Below				
Checked & Approved By	: SEE COMMENT Below				
Comment	: Est. B 02.07.26 Updated Location RF				

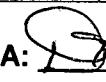
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) D2600-5-108 Extrusion 'I Beam' thin Batch: B10433 a.m 06-02-06 (4)</p>		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<p>Comment: LANDING GEAR RESOURCE 1 Cut D2600-5 Extrusion to length as per Dwg D2923. a.m 06-02-06 (4) Deburr ends a.m 06-02-06</p>		
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<p>Comment: LANDING GEAR RESOURCE 1 1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481 a.m 06-02-06 2- Open holes to finish size as per Dwg D2923. a.m 06-02-06 (4) 3- Deburr a.m 06-02-06</p>		
4.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP BE 06-02-06 (4)</p>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1 a.m 06-02-06 (4)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/20/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-02-07 (4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

a.m 06-02-07 (4)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Suc 06/02/08 (4) 06/02/08 (4)

Job Completion



W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

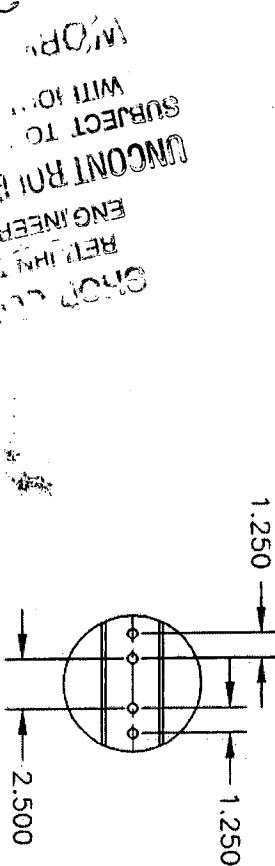
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

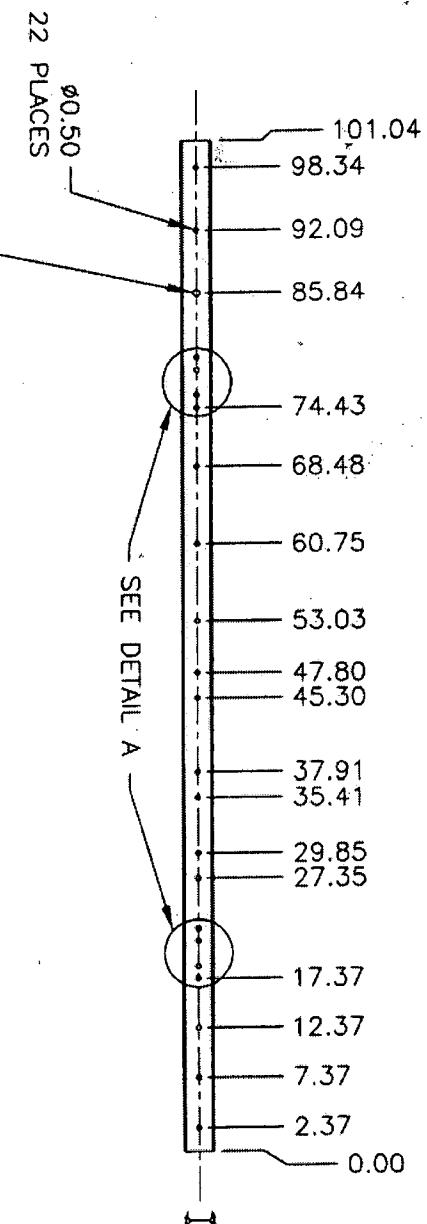
NOTE: Date & initial all entries

MAKE FROM D2600-5 EXTRUSION
 FINISH: ACID ETCH, ALDINE PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.05.11



DETAIL A
SCALE 1:9



SEE DETAIL A

DESIGN	DRAWN BY	DRAWDNG NO.	APPROVED	DATE	TITLE	WEB	99.10.14	99.10.14	NEW ISSUE
R.F.		D2923			SHEET 1 OF 1		REV. A	REV. A	SCALE 1:18



